Work Order I September-11-13 11	•	p 2 2 3 7	*106	629*							Page 1
Start Date: 10/ Required Date: 10/	ker Plate 17/13 Start Qty: 20.0	*20*	Accept	*N900 Cust Item I Customer:		100) * s	Setup Se	tart top	*N:	S1* S2*
	rocess Plan: ムロゴ		Tooling: SPC (Y/N):		nte:		I		tart Stop	*N *N	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr										
D2237	Rev D1										
100 *100* Waterjet FLOW CNC Waterjet 3.04.032*	FLOW WATER JET Memo 1-Cut as if necess	s per Dwg D Dwg Rev: 	0.00 0.00 Prog Rev: <i>D1</i>	2-Deburr			40	ひ	-	<u>.</u>	Jm3-11-1
110	QC2- Inspect parts o	ff machine FAI/FAIB	0.00								
110 QC Quality Control	Memo		0.00				40	0			Jm3-11.
*120 *120*	QC8- Inspect parts -	second check	0.00 DAS 27 9-89				40.				ta i
QC Quality Control	Мето		15 // c	24			Colum	7			

												DQA:	Da	ate:	
NCR:	es/	/ No				WORK ORDER NON-	COF	NFORM	MANCE / UP	DATE		•			
										-	Q	A Closed:	Da	ate:	
Work Orde	ı.					DISPOSITION				AGAINST DE	EP#	ARTMENT/	PROCESS		
WOIK Olde	٠					Rework	ا ٦		Skid-tube	Crosstube	7		Water Jet	: [Engineering
Part N	lo.					Scrap	1		Machining	Small Fab	1	Proc	d. Eng. Coor.	\vdash	Quality
	•		·			Use-as-is		Therm	noforming	Finishing		Rec/Stor	e/Packaging	:[Other
NCR N	۱o.					Work Order Update]		Large Fab	Composite			Supplier	·	
Root					Descri	tion of work order update	\top	nitial	Act	tion	Τ	Sign &			
Cause		Date	Step	Qty	,	or Non-conformance	Ch	ief Eng	Desci	ription		Date	Verification	n	QC Inspector
Doc/Data															
Equip/Tooling			[Ì							1				
Operator															
Material															
Setup							1								
Other				-	1			•							
Process							İ								
Supplier															
Training															
Unapproved				<u> </u>											
						F	AUL	T CATE	GORY						
Landi	ng (Gear				General		-		_	_				-
		Bending				Bend		Grain			၂၀	valized		\perp	Pressure/Forced
		Centre N	ot Conce	ntric to	o/s	BOM/Route	L	Hardwa	re		၂၀	ver/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	ion Incomplete		_ P	art Incorrec	:t	L	Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/l	Unclear	J₽	art Lost/Mi	ssing	L	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		JP	art Moved			
		Heat Trea	at			Countersink		Mislabe	eled		P	ositioned W	/rong		_
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	ţ		P	ower Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

Work Orde September-11-13				*106	3629*					·		Page	2
Item ID: Revision ID: Item Name:	D2237 Striker Plate			Accept	*N90	0040	100) *	Setup	Start Stop	1.71	S1* S2*	vd 8 - y voca - voca
Start Date: Required Date: Reference:	10/17/13 10/17/13	Start Qty: 20.00 Req'd Qty: 20.00	*20'		Cust Ite Customo						14	. 12	
Approvals:		an:	Date:	Tooling: SPC (Y/N):		Date:			Run	Start Stop	17	R1* R2*	
Sequence ID/ Work Center II 130 *120* Small Fab Small Fab) ,	Operation Description Small Fab Memo 1-Form as pe	er drawing	Set Up/ Run Hours 0.00	Tool I	D Tool#	Plan Code	Accep Qty 40	Qt		Reject Number	Insp. Stamp	80
*140 *140* QC Quality Control	. *	QC5- Inspect part comple	eteness to step on W/O	0.00 DAS 9-89 0.00 B. \\.	20			40					-
·					•						-		

150

Identify as per dwg & Stock Location: 57007 0.00

150
Packaging
Packaging

Memo

0.00

40 x 28 13-11-5

. .

									DQA:	Date:	
NCR: Y	es / No	ı			WORK ORDER NON-C	ONFO	RN	MANCE / UPDATE	QA Closed:	Date:	
NA/a als Oads					DISPOSITION			AGAINST DE			
Work Orde					Rework Scrap Use-as-is	The	١	Skid-tube Crosstube Machining Small Fab	ė .	Water Jet d. Eng. Coor.	Engineering Quality Other
NCR N	lo				Work Order Update] ''''		Large Fab Composite	necy stor	Supplier	
Root				Descri	ption of work order update	Initia		Action	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief E	ng	Description	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator		Ì						·			
Material											
Setup											
Other					•		l				:
Process		İ									
Supplier						ļ					
Training						l					
Unapproved							Δ				
					F.	AULT CA	TEC	GORY			
Landi	ng Gear				General				,		•
	Bendin	g		<u> </u>	Bend	Grai	in	·	Ovalized		Pressure/Forced
	Centre	Not Conce	entric to	o/s	BOM/Route	Hard	dwa	re	Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Insp	ecti	on Incomplete	Part Incorred	ct	Weld
	Crushe	d/Crimped	l	<u></u>	Burrs	Instr	ructi	ions Incomplete/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	Mai	inte	nance	Part Moved		
ļ	Heat T	reat			Countersink	Misl	labe	led	Positioned V	Vrong	

Misread

Out of Calibration
Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

Work Ord September-11-	,			*106	629*						Page 1	3
Item ID: Revision ID: Item Name:	D2237 Striker Plate			Accept	*N900	040	100)* s	etup Sta		S1* S2*	
Start Date: Required Date Reference:	10/17/13 :: 10/17/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item I Customer:	D:						
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:		F	Run Sta Sto	" [\] op .	R1* R2*	
Sequence ID/ Work Center	ID .	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number		
160 QC Quality Control		Мето		0.00						V [3-11	MF -{3'	n.08

											DQA:	Date	
NCR: Y	'es /	No				WORK ORDER NON-C	ON	FORN	MANCE / UPDATE		QA Closed:	Date	•
	· · · · · · · · · · · · · · · · · · ·				•	DISPOSITION			AGAIN	IST DE	PARTMENT		
Work Orde	er:						,]		_	_	i	<u></u>	1
Part N	lo					Rework Scrap		ı	Skid-tube Crosstu Machining Small F	ab		Water Jet	Engineering Quality
NCR N	lo					Use-as-is Work Order Update			noforming Finishi Large Fab Compos	~ - -	Rec/Stor	re/Packaging Supplier	Other
Root					Descri	ption of work order update	ln	itial	Action		Sign &		
Cause	C	ate	Step	Qty		or Non-conformance	Chie	ef Eng	Description		Date	Verification	QC Inspector
Doc/Data		İ											
Equip/Tooling							Ì						
Operator													
Material													
Setup		İ					ŀ						
Other			!										
Process													
Supplier													
Training													
Unapproved							<u> </u>						
						F/	AULT	CATE	GORY				
Landir	ng Gea	r				General	_				•	-	-
	Ber	nding				Bend 1	Ш	Grain			Ovalized		Pressure/Forced
	Cer	ntre No	t Concer	ntric to	o/s	BOM/Route	١	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cra	icks				Broken/Damaged		nspecti	on Incomplete		Part Incorred	ct	Weld
	Cru	ished/C	Crimped			Burrs		nstruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
	Cut	ffs				Contamination		Mainte	nance		Part Moved		
	He	at Trea	t			Countersink		Mislabe	eled		Positioned V	Vrong	

Misread

Out of Calibration
Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio September-11-13 11:09:41 AM

Work Order ID:

106629

Parent Item:

D2237

Parent Item Name:

Striker Plate

Start Date: 10/17/13

Required Date: 10/17/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP C02.05.11Clarify IPPNG
IPP D 06.05.25 Wateriet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA 304/316 .032 Sheet		Purchased	No			100	sf	450.5000	0.01	9.210526 O . 5		. Ju	<u> </u>
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT020		450.5							
				118	3271	10.76							
				120	0866	54.87							
				121	1889	64.87							
				m1:	26593	320			12.6	593			

Date:

DQA:

NCR: Ye	es / No				WORK ORDER NON-C	ONFOR	MANCE / UP	PDATE			
									QA Closed:	Date	::
Work Ordei	r·			,	DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	:
Part No					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
					Use-as-is	Ther	moforming	Finishing		re/Packaging	Other
NCR N	o				Work Order Update		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief En	g Desc	cription	Date	Verification	QC Inspector
Doc/Data	_										
quip/Tooling			1	•							
Operator	_										
Material			1 1								
Setup	_									j	
Other	_		1 1								
Process	_		1 .								
Supplier											
Training											
Jnapproved		<u> </u>					<u> </u>				
						AULT CAT	EGORY			_	
Landin	 1			_	General	— .			1		¬-
L	Bending				Bend	Grain		<u> </u>	Ovalized	_	Pressure/Forced
1	Centre N	ot Conce	ntric to C)/S	BOM/Route	Hardw		_	Over/Under	 -	Temperature/Cure
-	Cracks				Broken/Damaged	\vdash	tion Incomplete	—	Part Incorre	⊢	Weld
	Crushed/	Crimped		-	Burrs		ctions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
-	Cuffs			<u> </u>	Contamination	—	tenance	<u> </u>	Part Moved		
	Heat Trea			ļ	Countersink	Mislat		<u> </u>	Positioned V		¬₋.
	Inspectio	•	Tube	\vdash	Cut Too Short	Misre			Power Loss/	'Surge	Other
	Ripples in			lacksquare	Drill Holes	Offset					
	Torque V			' _	Drawing	\vdash	Calibration				
1	Turning S			L	Finish	Out o	Sequence				·
. [Wave/Tv	vist in Tul	be	j	Folio	Outsid	le Dimensions				

DART AEROSPACE LTD	Work Order:	1010629
Description: Striker Plate	Part Number:	D2237
Inspection Dwg: D2237 Rev: D1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

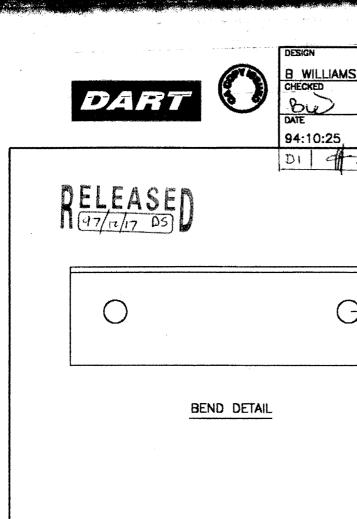
X	First Article		Prototype
---	---------------	--	-----------

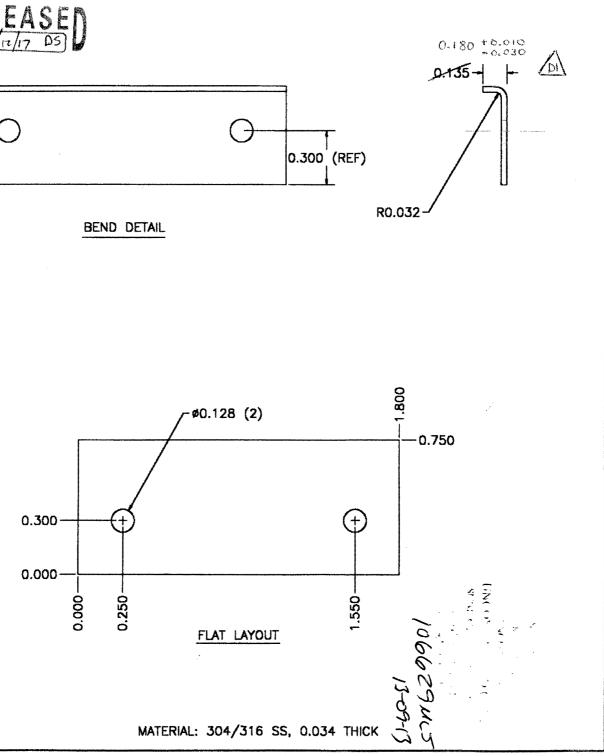
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300	+/-0.010	0.304"	-		U	Jamos
0.250	+/-0.010	0.255	_		U	
1.550	+/-0.010	/. 532`	_		ر	
1.800	+/-0.010	1.809"	-		J	
0.750	+/-0.010	D.753"	-		J	
Ø0.128	+0.005/-0.001	0,128"	_		U	
0.034	+/-0.010	0.031	_		0	
						-

Measured by: Jm Audited by: 27 9-89 Prototype Approval: N/A

Date: 13-11-1 Date: 12 11 04 Date: N/A

Rev	Date	Change	Revised by	Approve/d
Α	07.05.31	New Issue	KJ/JLM	
	J		70	





DRAWN BY

B WILLIAMS

DRAWING NO.

STRIKER PLATE

D2237

04.06.15 UPDATE DIMENSION

DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA

REV. D

SHEET 1 OF 1